

**Work Order ID 58871**

Wednesday, May 19, 2010 3:30:13 PM



Page 1

Item ID: D500-572-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 5/19/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: MDate: 10-5-19 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2435

Rev E1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D500-572-011 CHG005

S 10/06/11

HJ for BG 10/06/11

160

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

= 7 m. / 10/06/11

170

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

S 10/06/11

(82)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D500-572-011

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Required Date: 5/26/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD500-572-011 □ Location: <u>B</u>								
190 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Rev A

10-6-14

10/06/15

MF  
10-6-14

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Wednesday, May 19, 2010 3:30:18 PM

Page 1

Work Order ID: 58871

Parent Item: D500-572-011

Parent Item Name: Bearpaw

Comments: IPP Rev:C 04.02.17 Blank size changed KJ/JLM  
IPP Rev:D 07-01-02 Was K10007 JLM  
IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC  
IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Qty: 2.00

Required Qty: 2.00

QS200-M44S

Purchased No

120

Each

10.0000



Clamp

QS200 44S

M112679



4x m-h 10/06/11

Location

Loc Qty

Loc Code

ST450

10

113288

10

AN4-15A

Purchased No

170

Each

307.0000



Bolt



Location

Loc Qty

Loc Code

ST358

307

114239

26

114292

181

114615

100

AN960JD416

Purchased No

170

Each

0.0000



Washer

NA S1149004635

M114576



16x m-h 10/06/11

16x m-h 10/06/11

D2182B

Manufactured No

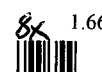
170

f

328.4138



Rubber Cushion



Location

Loc Qty

Loc Code

ST402A

9.67

30872

9.67

ST410

318.7438

52649

318.7438

3-332 m-h 10/06/11

(12182B050)  
QTY 4  
@ 5.00 per kit  
10.06.11  
measured  
5/10/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 58871



Parent Item: D500-572-011



Parent Item Name: Bearpaw

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments:

IPP Rev:C 04.02.17 Blank size changed KJ/JLM

IPP Rev:D 07-01-02 Was K10007 JLM

IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC

IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC

Start Qty: 2.00

Required Qty: 2.00

D2274 Manufactured No 170 Each 569.0000 16 8



Radius Block

Location Loc Qty Loc Code

ST010 569

54850 4

56686 59

57714 233

57912 273

D2435 Manufactured No 170 Each 0.0000 2



Bearpaw, 206

D2438 Manufactured No 170 Each 73.0000 8 4



Clamp

Location Loc Qty Loc Code

ST456 73

55603 73

D2529 Manufactured No 170 Each 622.0000 16 8



Washer

Location Loc Qty Loc Code

ST017 622

56184 22

58568 600

16x m-l 10/06/11

B58972 8x m-l 10/06/11

8x m-l 10/06/11

16x m-l 10/06/11

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 58871



Parent Item: D500-572-011



Parent Item Name: Bearpaw

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP Rev:C 04.02.17 Blank size changed KJ/JLM

Start Qty: 2.00

Required Qty: 2.00

IPP Rev:D 07-01-02 Was K10007 JLM

IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC

IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC

MS21042L4

Purchased

No

170

Each

2,791.000



Nut

## Location

## Loc Qty

## Loc Code

ST139

2

111827

2

ST300

2789

113422 ✓

80

114523 ✓

1701

114718

1000

9063

8

16X

m-k 10/06/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## REFERENCE ONLY

## 32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-572-011 Bearpaw Installation	8.5 lb 3.86 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	130 in 3.30 m	1105 in-lb 12.74 m-kg
D500-572-021 Narrow Bearpaw Installation	7.5 lb 3.41 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	130 in 3.30 m	975 in-lb 11.25 m-kg
D500-572-013 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	128 in 3.25 m	1459 in-lb 16.80 m-kg
D600-572-015 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	122 in 3.10 m	1391 in-lb 16.03 m-kg

## 32.4 PARTS LIST

Qty D500 -572 -011	Qty D500 -572 -021	Qty D500 -572 -013	Qty D600 -572 -015	Part Number	Description
X				D500-572-011	BEARPAW INSTALLATION
	X			D500-572-021	NARROW BEARPAW INSTALLATION
		X		D500-572-013	BEARPAW INSTALLATION
			X	D600-572-015	BEARPAW INSTALLATION
2				D2435	BEARPAW
	2			D2671	BEARPAW
		2		D2995	BEARPAW
			2	D2996	BEARPAW
4	4	4		D2182B050	RUBBER CUSHION
			4	D2182B060	RUBBER CUSHION
8	8	8	8	D2274	RADIUS BLOCK
4	4	4		D2438	CLAMP
			4	D2519	CLAMP
8	8	8	8	D2529	WASHER
		8	8	AN4-13A	BOLT
8	8			AN4-15A	BOLT
8	8	8	8	AN960JD416	WASHER
8	8	8	8	MS21042L4	NUT (OR MS21042-4)
2	2			QS200M44S	CLAMP
			4	QS100M24S	CLAMP

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